



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

DAS
21
9-89

D2731-3

Job Sheet 180269



Part No: D2731-3

Job Qty: 30 ea

Part Name: Mounting Lug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/4/18

Job Tracking No:

Due Date: 8/15/18

Created By: Chantal Lavoie

Type: Stock

Description:

Note: DWG REV C IPP: D 00.05.19 Added inspect level 8, removed P/O for powder coating EC IPP REV:E 13.06.25
OUTSOURCE METEC DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	30 pcs	8/15/18	8/15/18	0.00	0.00	Purchasing		AUG 17 2018
120	Packaging	30 pcs	8/15/18	8/15/18	0.00	0.00	Packaging2		AUG 17 2018
130	QC	30 pcs	8/15/18	8/15/18	0.00	0.00	QC6		15-08-20
140	HandFinish	30 pcs	8/15/18	8/15/18	0.00	1.00	HandFinish1		N/R
150	Powdercoat	30 pcs	8/15/18	8/15/18	0.00	1.20	Powdercoat1		
160	QC	30 pcs	8/15/18	8/15/18	0.00	0.00	QC3		
170	Packaging	30 pcs	8/15/18	8/15/18	0.00	0.00	Packaging3-1	37.5206	AUG 23 2018
180	QC21-SA	30 Ea	8/15/18	8/15/18	0.00	0.00	QC21		21 AUG 23 2018

Part Op 110 - Outsource process - Machining Issue P/O to Metec : P0040391 Machine as per dwg C of C is required
 Descriptions: 120 - Receive & Inspect for Damage & Mat'l Certs ENSURE C OF C IS ATTACH.
 130 - QC6- All purchased or subcontracted products
 140 - Chemical Conversion Coat per QSI005 4.1
 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
 160 - QC3- Inspect Part Finish
 170 - Identify as per dwg & Stock Location: _____
 180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2423	Lug Extrusion	2.0490 ft (.0683 ea)	110-Purchasing	5103179.
D2731-3P	Lug	30 pcs (1 ea)	110-Purchasing	5102511
				510512.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D2423	2	53	0
	D2731-3P	30	0	0



Container No: S103182



Part: D2731-3

Job No: 180269

Serial No/Batch: S103182

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

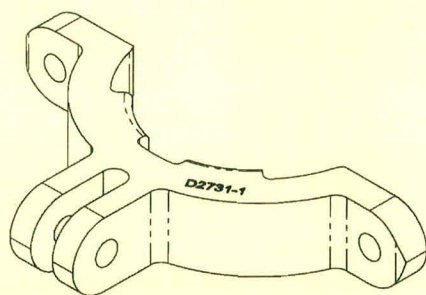
Date: 08/17/10

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

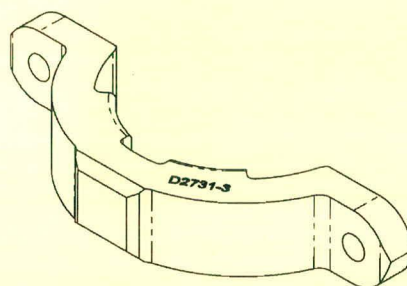
S103182
D2731-3
180269

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Lug	4.450Inches $\pm$ 0.010	4.460 4.440		
2	Mounting Lug	1.410Inches $\pm$ 0.030	1.440 1.380		
3	Mounting Lug	0.306Inches $\pm$ 0.010	0.316 0.296		
4	Mounting Lug	0.413Inches $\pm$ 0.010	0.423 0.403		
5	Mounting Lug	3.700Inches $\pm$ 0.005	3.705 3.695		
6	Mounting Lug	0.375Inches $\pm$ 0.010	0.385 0.365		
7	Mounting Lug	0.750Inches $\pm$ 0.010	0.760 0.740		
8	Mounting Lug	0.257Inches + 0.005 - 0.000	0.262 0.257	Diameter	
9	Mounting Lug	0.100Inches $\pm$ 0.010	0.110 0.090		
10	Mounting Lug	45.000Degrees $\pm$ 0.000	45.000 45.000	Angle	
11	Mounting Lug	0.060Inches + 0.040 - 0.000	0.100 0.060	Radius	

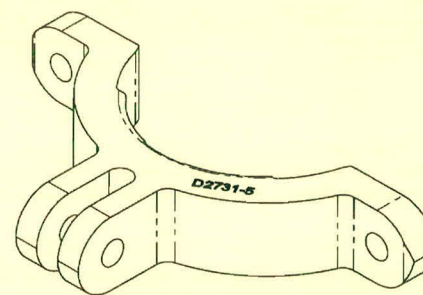
Plex 7/4/18 8:34 AM dart.lavoie.chantal



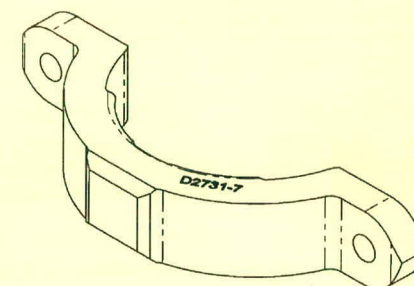
D2731-1 MOUNTING LUG



D2731-3 MOUNTING LUG



D2731-5 MOUNTING LUG



D2731-7 MOUNTING LUG

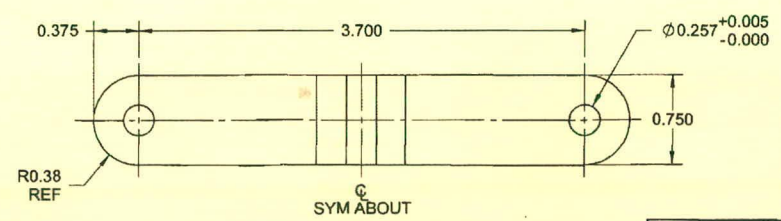
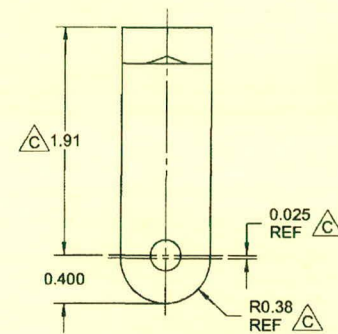
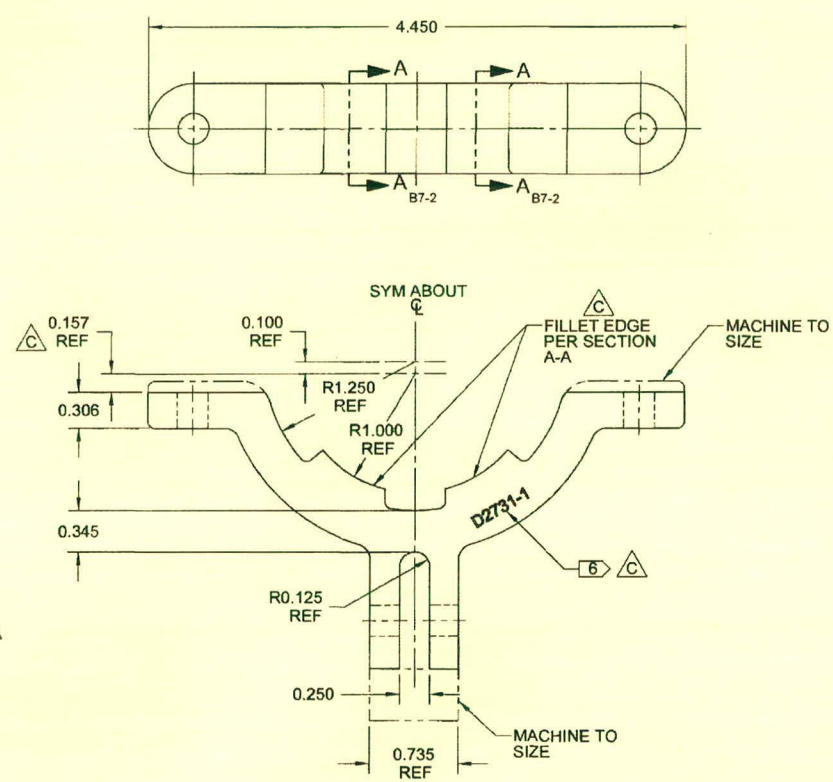
**DEO ATTACHED
RELEASED**
09/01/19

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.17 lbs
-3: 0.15 lbs
-5: 0.16 lbs
-7: 0.14 lbs

C	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A, B-B, C-C & D-D FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.19
B	REVISED DIMENSIONS	KE	99.07.06
A	NEW ISSUE	KE	98.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	AJS	DRAWING NO.	REV. C
CHECKED		D2731	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		MOUNTING LUG	NTS
DE APPR.		COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DATE	09.01.19		

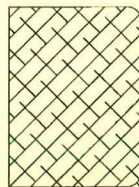
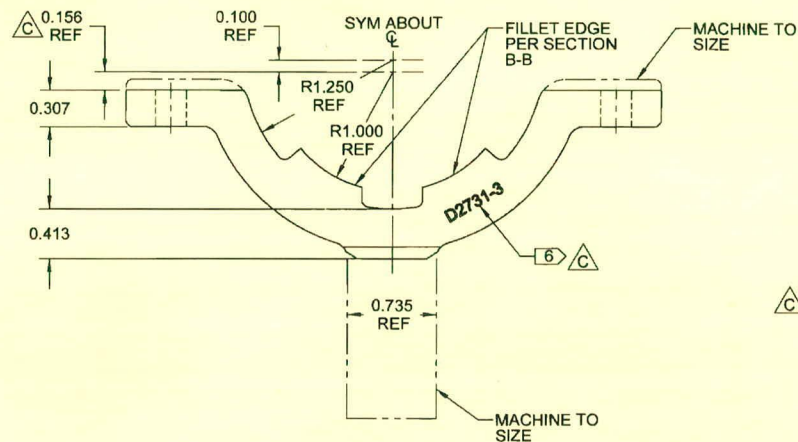
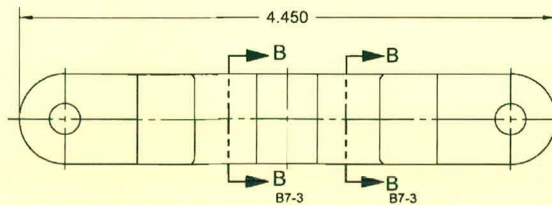
SECTION A-A
SCALE 2X
D4-2
2 PL
R0.06 MIN-R0.10 MAX



D2731-1 MOUNTING LUG

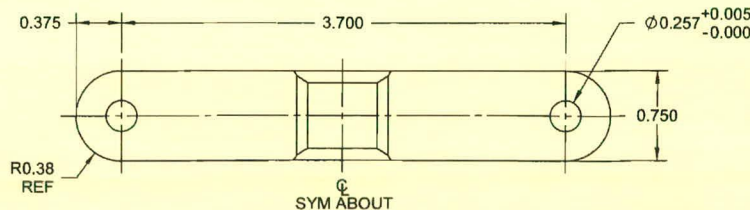
DEO ATTACHED
RELEASED
09/06/25 AW

DESIGN	KE	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO. D2731	REV. C
MFG. APPR.		TITLE MOUNTING LUG	SHEET 2 OF 5
APPROVED		SCALE	NTS
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R0.06 MIN-R0.10 MAX $\triangle C$
2 PL

$\triangle C$ SECTION B-B D4-3
SCALE 2X

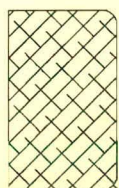


D2731-3 MOUNTING LUG

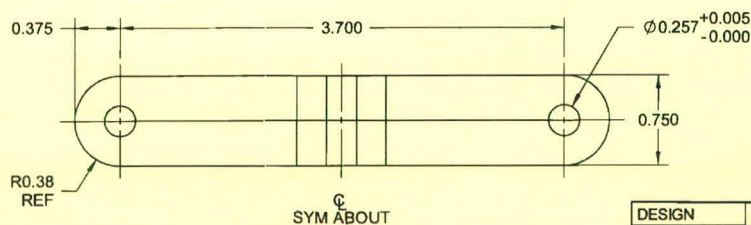
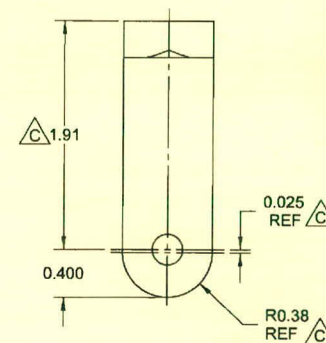
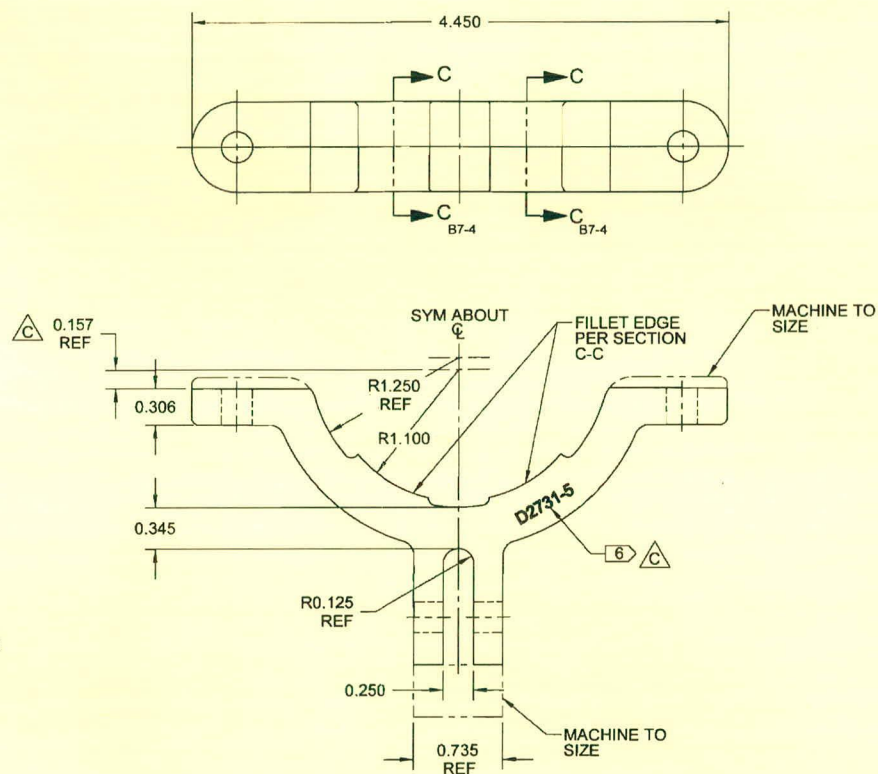
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09/05/25

DESIGN	KE	DART AEROSPACE USA, INC.	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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SECTION C-C D4-4
SCALE 2X



R0.06 MIN-R0.10 MAX
2 PL



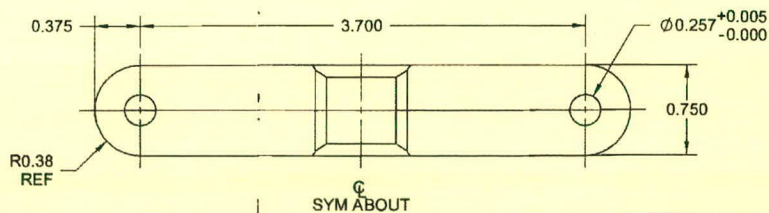
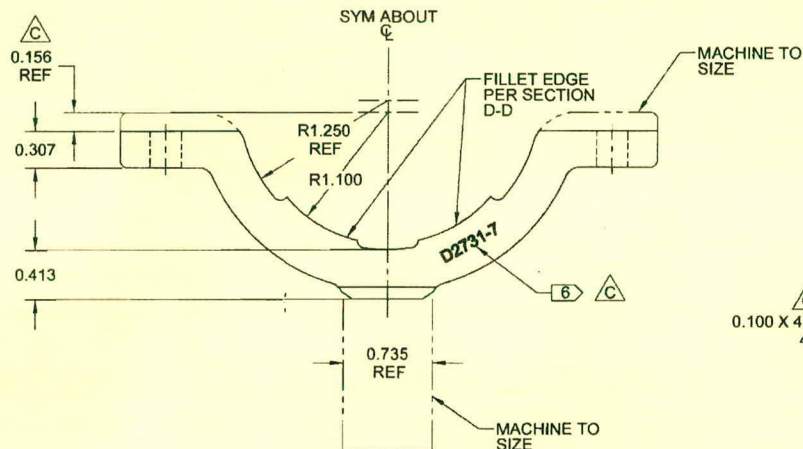
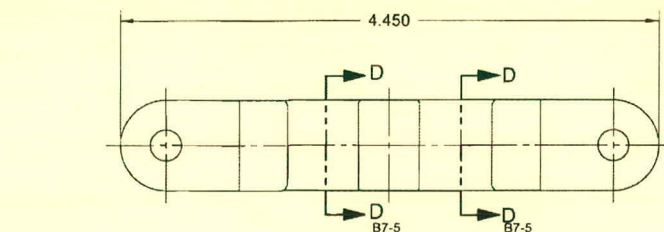
D2731-5 MOUNTING LUG

**DEO ATTACHED
RELEASED**
9/16/25 JWP

DESIGN	KE	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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SECTION D-D D4-5
SCALE 2X

R0.06 MIN-R0.10 MAX
2 PL



D2731-7 MOUNTING LUG

DESIGN	KE	DART AEROSPACE USA, INC.	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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**DEO ATTACHED
RELEASED**
09/06/25/17

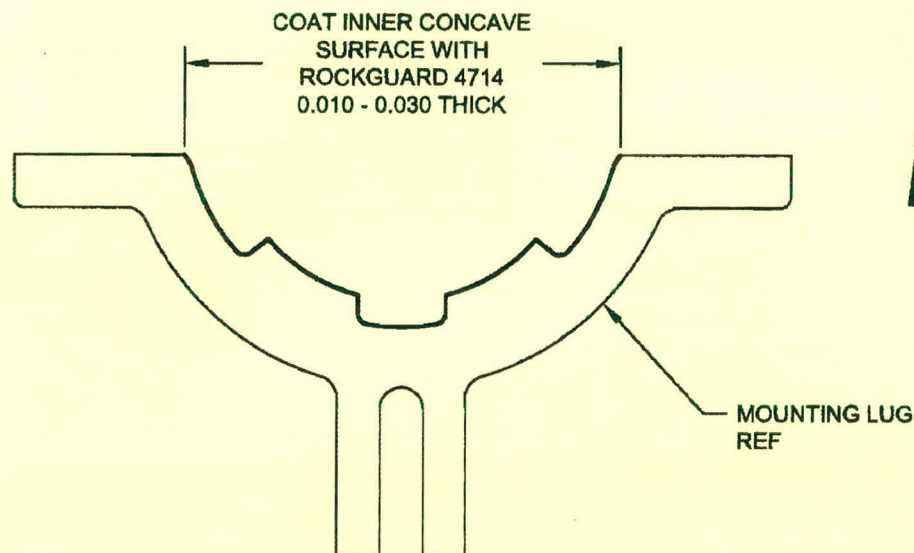
DRAWING NO. D2731	TITLE MOUNTING LUG	REV. C	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D2731-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 97	CHECKED SC	MFG. APPR. MA	APPROVED MD		DE APPR. TH		
DATE 11.05.02	DATE 11.05.09	DATE 11.05.09	DATE 11.05.09		DATE 11.05.09		

PURPOSE

ADD D2731-xRG OPTION

CHANGE

D2731-xRG MOUNTING LUGS ARE IDENTICAL TO D2731-x MOUNTING LUGS, HOWEVER AFTER FINISH, COAT INNER CONCAVE SURFACE WITH "PLUS ONE ROCKGUARD 4714" AS SHOWN BELOW.



D2731-1RG MOUNTING LUG (SHOWN)
D2731-3RG/-5RG/-7RG MOUNTING LUGS (SIMILAR)

RELEASED
2011-05-24
MD



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040391**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040391

PO Date: 7/4/18

Due Date: 8/20/18

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Baker, Diane Phone:
dbaker@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Revision

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	180263	D2230-1P			Lug As Per Dwg D2230 Rev. G Alodine and Paint as per QSI 005	Firmed	-	8/20/18	100 pcs	0 pcs	100 pcs	\$17.40/pcs	\$1,740.00
								62X AUG 15 2018					
2	180266	D2230-3P			Lug As Per Dwg D2230 Rev. G Alodine and Paint as per QSI005	Firmed	-	8/20/18	100 pcs	0 pcs	100 pcs	\$14.90/pcs	\$1,490.00
3	180269	D2731-3P			Lug As Per Dwg D2731 Rev.C	Firmed	-	8/20/18	30 pcs	0 pcs	30 pcs	\$16.20/pcs	\$486.00
								32X AUG 15 2018					
4	180272	D3394-1P			Lug As Per Dwg D3394 Rev. B	Firmed	-	8/20/18	30 pcs	0 pcs	30 pcs	\$20.45/pcs	\$613.50
								30X AUG 15 2018					
5	180273	D3910-1P			Crosstube Lug As Per Dwg D3910 Rev. E Alodine and Paint as pe QSI 005	Firmed	-	8/20/18	20 pcs	0 pcs	20 pcs	\$17.40/pcs	\$348.00
								20X AUG 15 2018					
6	180275	D3910-3P			Crosstube Lug As Per Dwg D3910 Rev. E Alodine and Paint as Per QSI 005	Firmed	-	8/20/18	20 pcs	0 pcs	20 pcs	\$17.40/pcs	\$348.00
7	180277	D3910-7P			Crosstube Lug As Per Dwg. D3910 Rev. E Alodine and Paint as Per QSI 005	Firmed	-	8/20/18	20 pcs	0 pcs	20 pcs	\$17.40/pcs	\$348.00
								20X AUG 15 2018					

Plex 7/10/18 9:11 AM dart.Lussier.Patrick

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Grand Total:												\$5,373.50	
Order Notes													
Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.													
Procurement Quality Clauses													
A005 RIGHT OF ENTRY													
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)													
A012 CHEMICAL AND PHYSICAL TEST REPORTS													
A016 PERSONNEL QUALIFICATION													
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)													
A026 CERTIFICATION OF MATERIAL CONFORMANCE													
A041 QUALITY MANAGEMENT SYSTEM													
A042 DART NOTIFICATION BY SUPPLIER													
A043 RETENTION OF QUALITY DOCUMENT													
A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM													
A049 SUPPLIER AWARENESS													

Plex 7/10/18 9:11 AM dart.Lussier.Patrick

**METAL TECHNOLOGY INC.**

20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 22853

Date:

Aug 15, 2018

Page:

1

Sold to:	Ship to:
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO040391 NC	Sold By: Walz, Christian D.
Shipped By: pick up	Ship Date: Aug 15, 2018

Description	Bin Loc	Unit	Quantity ordered	Quantity shipped	Quantity on B/O
D2230-1 Mounting Lug ✓ 62 in stock alodined and painted as per QSI 005		Each	100	62 ✓	38
D2230-3 Mounting Lug no stock alodined and painted as per QSI 005		Each	100		100
D2731-3 ✓ Mounting Lug in stock alodined and painted as per QSI 005		Each	30	32 ✓	DAS 61 9-89
D3394-1 Lug ✓ in stock alodined and painted as per QSI 005		Each	30	30 ✓	
D3910-1 ✓ Crosstube Lug in stock alodined and painted as per QSI 005		Each	20	20 ✓	
D3910-3 Crosstube Lug no stock alodined and painted as per QSI 005		Each	20		20
D3910-7 Crosstube Lug ✓ in stock alodined and painted as per QSI 005		Each	20	20 ✓	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.					

Received by _____

Thank you for your order!



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Material Batch #	Paint Batch #	P.O. Number
30	D3394-1	Lug	115529	21778	40391
20	D3910-7	Crosstube Lug	131451	20366	40391
DAS 20	D3910-1	Crosstube Lug	160522	22006	40391
61 32	D2731-3	Lug	127892	20082	40391
9-89 62	D2230-1	Mounting Lug	160522	21965	40391

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, August 15, 2018

